



Dart Aerospace Ltd.
1270 Aberdeen St
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Tel (613) 632-5200
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D3183-044
Job Sheet 200404



Part No: D3183-044

Job Qty: 4 pcs

Part Name: Bracket Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/11/19

Job Tracking No:

Due Date: 11/13/19

Created By: Jennifer Renwick

Type: Stock

Description:

Note: DWG REV C1 IPP Rev:Pick:A 04.02.18 New issue KJ/DS IPP Rev:B Changed Mat Size 08-06-26 JLM Verified By:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	4 pcs	11/13/19	11/13/19	0.00	0.06	Bandsaw - 1		Uu. 2019/10/16 DAS 64 9-89
110	HAAS 4 Axis - B4B	4 pcs	11/13/19	11/13/19	0.87	16.67	HAAS - 1 - B4B		
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		Uu. 2019/11/19 DAS 64 9-89
120	QC 2	4 pcs	11/13/19	11/13/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		



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Container No: S234285



Part: D3183-044

Job No: 200404

Serial No/Batch: S234285

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 11/23/19

Plex 9/11/19 8:32 AM Dart.Renwick.Jennifer

				QC 2 - 51	
				QC 2 - 52	
				QC 2 - 57	
				QC 2 - 62	
				QC 2 - 63	
				QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	MM 2019/11/19
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
130	QC 8	4 pcs	11/13/19	0.00 0.00	QC 8 - 12
					QC 8 - 14
					QC 8 - 17
					QC 8 - 20
					QC 8 - 25
					QC 8 - 3
					QC 8 - 32
					QC 8 - 33
					QC 8 - 35
					QC 8 - 39
					QC 8 - 4
					QC 8 - 44
					QC 8 - 45
					QC 8 - 49
					QC 8 - 58
					QC 8 - 8
					QC 8 - 9
					QC 8 - 68
					QC 8 - 67
					QC 8 - 1 (A)
					QC 8 - 47
					QC 8 - 40
					QC 8 - 52
					QC 8 - 23
					QC 8 - 57
					QC 8 - 76
140	Small Fab - 2 - B4B	4 pcs	11/13/19	0.00 0.21	Small Fab - 1 - B4B
					Small Fab - 2 - B4B
					Small Fab - 3 - B4B
					Small Fab - 4 - B4B
					Small Fab - 5 - B4B
					Small Fab - 6 - B4B
					Small Fab - 7 - B4B
					Small Fab - 8 - B4B
150	QC 5	4 pcs	11/13/19	0.00 0.00	QC 5 - 10
					QC 5 - 12
					QC 5 - 17
					QC 5 - 18
					QC 5 - 19
					QC 5 - 22
					QC 5 - 24

BAS
64
9-89

19-11-26

DEC 02 2019

					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	DAS 40
					QC 5 - 40	DEC 02 2019 9-89
					QC 5 - 61	
					QC 5 - 81	
160	Packaging 3-1 - Stock - B4B 4 pcs	11/13/19	0.00	0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	DAS 28
					Packaging 3 - 7 - B4B	9-89
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
170	QC 21 - SA 4 pcs	11/13/19	0.00	0.00	QC 21 - SA - 21	DEC 04 2019
					QC 21 - SA - 70	
					QC 21 - SA - 53	DAS 21 9-89
Part Op 100 - (Bandsaw) Cut blanks: (1.500" x 2.250") 5.500" long Descriptions: 110 - (HAAS CNC Vertical Machine) 1-Machine D3183-4 as per Folio FA322 and Dwg D3183 Identify as D3183-4 120 - (QC2- Inspect parts off machine FAI/FAIB) 130 - (QC8- Inspect parts - second check)						

140 - (Small Fab) Assemble D3183-044 as per Dwg D3183.

150 - (QC5- Inspect part completeness to step on W/O)

160 - (Identify as per dwg & Stock Location: _____)

170 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M17-4-B1.500X2.250	17-4 SS Bar 1.50 X2.250	1.8332 ft (.4583 ea)	100-Bandsaw - 1	M127895
D3121-21	Bolt	8 pcs (2 ea) <i>ST018</i>	140-Small Fab - 2 - B4B	<i>5829846</i>
D3183-045	Bearing Assembly	8 pcs (2 ea) <i>ST081</i>	140-Small Fab - 2 - B4B	<i>7x5235254-1x5233608</i>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M17-4-B1.500X2.250	2	13	0
140-Small Fab - 2 - B4B	D3121-21	8	50	0
	D3183-045	8	13	0

Part Specifications

Specifications could not be found.

Plex 9/11/19 8:32 AM Dart.Renwick.Jennifer

DART AEROSPACE LTD		Work Order:	200404
Description: Bracket		Part Number:	D3183-4
Inspection Dwg: D3183	Rev: C1	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
R0.190	+/-0.030	R.190 OK	✓		Gaborit	
R0.063	+/-0.010	R.063 OK	✓		Gaborit	
0.182	+/-0.010	.182	✓		Vernier	
0.070	+/-0.010	.1060	✓		Vernier	
0.100	+/-0.010	.095	✓		Vernier	
Ø0.201 x 0.100	+/-0.010	.199 x 100 F	✓		Vernier et pin gauge	
0.182	+/-0.010	.182	✓		Vernier	
5.32	+/-0.030	5.326	✓		high gauge	
5.036	+/-0.010	5.038	✓		high gauge	
2.120	+/-0.010	2.120	✓		high gauge	
1.290	+/-0.010	1.290	✓		Vernier	
0.365	+/-0.010	.369	✓		Vernier	
0.218	+/-0.010	.217	✓		Vernier	
1.030	+/-0.010	1.026	✓		Vernier	
1.90	+/-0.030	1.888	✓		Vernier	
1.012	+/-0.010	1.011	✓		high gauge	
Ø0.201 x 0.100	+/-0.010	.199 x 100 F	✓		Pin gauge et vernier	
0.786	+/-0.010	.781	✓		high gauge	
Ø0.392	+0.002/-0.000	.393	✓		Micrometre + bearing	
R0.19	+/-0.030	R.190	✓		Gaborit	
3.954	+/-0.010	3.955	✓		high gauge	
0.162	+/-0.010	.159	✓		Vernier	
R0.19	+/-0.030	R.0.190 OK	✓		Gaborit	
R0.25	+/-0.030	R.250 OK	✓		Gaborit	
4.26	+/-0.030	4.261	✓		high gauge	
2.800	+/-0.030					
Calculated dimension						
0.162	+/-0.010	.161	✓		Vernier	
0.615	+/-0.010	.619	✓		Vernier	
0.435	+/-0.010	.432	✓		Vernier	
0.200	+/-0.010	.200	✓		Vernier	
0.381	+/-0.010	.382	✓		Vernier	
0.032	+/-0.010	.031	DKS		micrometre profundeur	

Measured by: <u>U.U.</u>	Audited by: <u>20</u>	Preliminary Approval:	N/A
Date: <u>2019/11/20</u>	Date: <u>19-11-20</u>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.11.12	New Issue P/O D3183-044	KJ/RF	
B	04.03.15	Changes as per revision C	KJ/JLM/RF	
C	04.06.15	Dimension 2.800 was 2.080; removed 1.155, 0.36 dimensions	KJ/JLM	
D	06.03.09	Dwg Rev update	KJ/JLM	
E	08.01.16	Dimensions revised	KJ/EC/DD	
F	10.09.23	Dimensions revised	KJ	<u>M</u>